



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D350-636-011
Job Sheet 171309



Part No: D350-636-011

Job Qty: 1 ea

Part Name: Skidtube LH, Std Wearplates, DART (Apical) Cylindrical/Aerazur Float Comp.



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 1/30/18

Job Tracking No:

Due Date: 2/9/18

Created By: Michelle Gagnon-Donovan

Type: SOLD

Description:

Note: D2750-041 REV G SHEETS 1,2,4,8 IPP Rev:I 02.09.25 IPP Rev:J 06-03-23 As per Rev D IPP Rev:K 06-07.13
As per dsi9343 IPP Rev:L 07-07-28 Added SS Wearplates(Rev E) JLM Verf:EC IPP Rev:M 08-04-22 DD
verified:EC IPP Rev:N 08-09-23 revF DD verified:ec IPP Rev:O 09-02-06 per PAR09-010 DD verf:EC IPP
Rev:P 10.06.22 revise seq110 DD verf:EC IPP Rev:Q 10.10.01 as per IIN revH DDverf:EC IPP REV:R
13.08.27 PER ECN13-594 DD VERF:JLM

Ship Via:

Bill of Materials

DART
AEROSPACE
S040992



Skidtube LH, Std Wearplates, DART (Apical)
Cylindrical/Aerazur Float Comp.

PART NO: D350-636-011

Original Serial #: S040992

Revision:

Operation:

Start up Operation 02/09/18

Change No:

CHG007

Job No: 171309

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S040992x1xLH

plex 1/30/18 4:01 PM Dart.Gagnon.Michelle

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		2/8/18	0.00	0.00	Start Up Skidtubes-1		
110	Skidtubes	1 pcs		2/8/18	0.00	4.55	Skidtubes-4		
120	QC	1 pcs		2/8/18	0.00	0.00	QC10		
130	QC	1 pcs		2/8/18	0.00	0.00	QC5		
140	HandFinish	1 pcs		2/8/18	0.00	0.93	HandFinish1		
150	QC	1 pcs		2/8/18	0.00	0.00	QC7-2		
160	Skidtubes	1 pcs		2/8/18	0.00	4.55	Skidtubes-4		
170	QC	1 pcs		2/8/18	0.00	0.00	QC10		
180	QC	1 pcs		2/8/18	0.00	0.00	QC5		
190	HandFinish	1 pcs		2/8/18	0.00	0.93	HandFinish2		
200	SprayPaint	1 pcs		2/8/18	0.00	0.53	Spray Paint		
210	QC	1 pcs		2/8/18	0.00	0.00	QC14		
230	HandFinish	1 pcs		2/9/18	0.00	0.93	HandFinish4		
240	QC	1 pcs		2/9/18	0.00	0.00	QC5		
250	Packaging	1 pcs		2/9/18	0.00	0.00	Packaging1-3		
260	QC	1 pcs		2/9/18	0.00	0.00	QC4		
265	DC	1 pcs		2/9/18	0.00	0.00	DC		
270	Packaging	1 pcs		2/9/18	0.00	0.00	Packaging3-1		
280	QC21-FG	1 Ea		2/9/18	0.00	0.00	QC21		

Part Op 110 - 1- Pick D2600-3 Bent 2- Deburr FWD and AFT ends, remove bending marks, 3- Re-bend tube inside AFT end per dwg
 Descriptions: D2750-1 3- Drill pilot holes for blade fitting bolt holes using DT8983. Start with 3/16", then open to 0.500" using center drill
 then ream holes using 0.500" reamer. PIN first side. Repeat process on second side. ***ENSURE PROPER
 POSITIONING FWD BEND MUST BE FACING UP WHEN DRILLING FIRST SIDE*** Drill pilot holes as per Dwg D2750
 sheet 4 (D2750-1 details). Drill using drill Jig DT8150 & DT8863A for 2nd side only DT8863B for first side (detail B) 4-
 Locate DT8330 off of blade fitting bolt holes and drill pilot holes for blade fitting. Open to 0.500" using hole saw. VERIFY
 AND RECORD FWD BEND ANGLE. 5-Drill pilot holes for wearplates as per Dwg D2750 using DT8108 open to 0.297". 6-
 Open up holes of Detail A to 0.297" (total of 2 holes per side) 7-Weld D2744 Cap as per Dwg D2750 and QSI 004. Fill
 grooves in bend left from bending as per QSI 004 A/R Aluminum Rod batch: M138673 8-Grind welds flush as per Dwg
 D2750
 160 - 1-Open up holes using hole saw of Detail C and ground handling to 0.625" (total of 8 holes per side) as per dwg
 D2750. 2-Open up holes using hole saw of Detail B to 0.750" (total of 4 holes per side) as per dwg D2750. 3- Open float
 hole using un-bit to 0.500" (4 per side) 4-Chamfer holes of Detail B, C, ground handling and float holes per dwg D2750
 (welding instructions on sheet 8) 5-Deburr and blow out all chips from inside of tube 6- Prepare tube for welding, remove
 alodine as required. 7-Bond web D2739 in place as per QSI 015, let cure for 12hrs. A/R Sikaflex-291 batch: M138654
 exp. date: 2018-04-21 ***ATTN: USE I-BEAM LOCATION AID (BLADE FITTING)*** 8- Weld spacers D3490-1, D3490-3
 and D2743 as per dwg D2750 & QSI004 (welding instructions on sheet 8) A/R Aluminum Rod batch: M138673 9- At
 section AJ-AJ drill out x-bolt spacer to 0.404" 10-Grind welds flush as per Dwg D2750 11-Spot face ground handling holes
 section (total of 4 places per side) as per dwg D2750 12-Deburr holes, ensure tube is free of all scratches before sending
 to paint.
 180 - ***VERIFY C'BOARD IS GOOD***
 190 - Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch.
 200 - 1- PRIME AS PER DWG AND QSI 005 4.2 PRIMER PRC DESOTO 515X349 BATCH: _____ 2-
 PAINT WHITE AS PER DWG AND QSI 005 4.2 PAINT BATCH: _____
 210 - Inspect for foreign object per QSI 024
 230 - 1- Install inserts as per Dwg D2750 2-Inspect for Foreign Objects 3- Install blade fitting D3488-041, wearshoes and
 ground handling hardware as per dwg D2750 SIKA FLEX 241 BATCH: M138654 EXP DATE: 18/04 4-
 Assemble o-ring to plug as per dwg D3492 and apply o-ring lube A/R 55-o-ring lube batch: M135477 5- Coat all
 exposed fasteners with "LPS Procyon" batch: M133690
 260 - *****ensure antiseize is on AN8C21A bolts*****
 265 - record fwd angle: 89.9 Photocopy blue file and type labels per PPP D350-636-011 CHG 007
 270 - Package as per PPP D350-636-011 Location : FG072

P10: 039200

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Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
D2600-3-BENT-LH	Extrusion Bent LH	1 Ea (1 ea)	90-Start up Operation	503/538
D2744	Cap	1 Ea (1 ea)	90-Start up Operation	5003318
D2739	350 I-Beam	1 Ea (1 ea)	160-Skidtubes	5040307
D2743	Crossbolt Spacer	8 Ea (8 ea)	160-Skidtubes	5026588
D3490-1	Cross Bolt Spacer	4 Ea (4 ea)	160-Skidtubes	5017322
D3490-3	Cross Bolt Spacer	4 Ea (4 ea)	160-Skidtubes	5030890
AN3C5A	Bolt	34 Ea (34 ea)	230-HandFinish	
AN3C6A	Bolt	4 Ea (4 ea)	230-HandFinish	
AN6C44A	Bolt	4 Ea (4 ea)	230-HandFinish	
AN8C35A	Bolt	1 Ea (1 ea)	230-HandFinish	
D2745	Bushing	8 Ea (8 ea)	230-HandFinish	
D3488-041	Blade Fitting LH	1 Ea (1 ea)	230-HandFinish	
D3492-1	Plug	8 Ea (8 ea)	230-HandFinish	
D3492-3	Plug	8 Ea (8 ea)	230-HandFinish	
D3535-25	Wearplate Center	1 Ea (1 ea)	230-HandFinish	
D3536-25	Gasket Center	1 Ea (1 ea)	230-HandFinish	
D3537-1	Wearpad	3 Ea (3 ea)	230-HandFinish	
D3631-1	Washer	8 Ea (8 ea)	230-HandFinish	
D3791-1	Wearpad	1 Ea (1 ea)	230-HandFinish	
D3793-1	Wearplate Fwd	1 Ea (1 ea)	230-HandFinish	
D3793-3	Wearplate Aft	1 Ea (1 ea)	230-HandFinish	
D3794-1	Gasket Fwd	1 Ea (1 ea)	230-HandFinish	
D3794-3	Gasket Aft	1 Ea (1 ea)	230-HandFinish	
MS21043-6	Nut	4 Ea (4 ea)	230-HandFinish	
MS21083C8	Nut	1 Ea (1 ea)	230-HandFinish	
NAS1149C0332R	Washer	38 Ea (38 ea)	230-HandFinish	
NAS1149C0832R	Washer	1 Ea (1 ea)	230-HandFinish	
NAS1515H3L	Washer	4 Ea (4 ea)	230-HandFinish	
NAS1611-010	O-Ring	8 Ea (8 ea)	230-HandFinish	
NAS1611-013	O-Ring	8 Ea (8 ea)	230-HandFinish	
ALS4-1032-225	Rivnut	38 Ea (38 ea)	230-HandFinish	
AN8C21A	Bolt	2 Ea (2 ea)	250-Packaging	
D2741	Replacement Blade	1 Ea (1 ea)	250-Packaging	
D3493-1	Washer	2 Ea (2 ea)	250-Packaging	
D3532-1	Spacer	2 Ea (2 ea)	250-Packaging	
MS21083C8	Nut	2 Ea (2 ea)	250-Packaging	
NAS1149D0863J	Washer	2 Ea (2 ea)	250-Packaging	

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D2600-3-BENT-LH	1	3	0
	D2744	1	2	0
160-Skidtubes	D2739	1	7	0
	D2743	8	151	0
	D3490-1	4	44	0
	D3490-3	4	27	0
230-HandFinish	ALS4-1032-225 5048375	38	1,399	0
	AN3C5A 5019396	34	1,069	0
	AN3C6A 5019397	4	222	0
	AN6C44A FM137055	4	487	0
	AN8C35A FM137203	1	83	0
	D2745 5026936	8	185	0
	D3488-041 5040145	1	5	0
	D3492-1 5025647	8	179	0
	D3492-3 5026057	8	232	0
	D3535-25 5032628	1	20	0
	D3536-25 5046424	1	23	0
	D3537-1 5037408	3	18	0
	D3631-1 5048060	8	134	0
	D3791-1 5024390	1	18	0
	D3793-1 5038363	1	19	0
	D3793-3 5032647	1	25	0
	D3794-1 5031919	1	27	0
	D3794-3 5046244	1	17	0
	MS21043-6 5041601	4	67	0
	MS21083C8 5034401	1	123	0
	NAS1149C0332R 5044236	38	3,099	0
	NAS1149C0832R M138409-121	1	108	0
	NAS1515H3LF M13736-25	4	435	0
	NAS1611-010 5022098	8	359	0
	NAS1611-013 5022099	8	447	0
250-Packaging	AN8C21A	2	209	0
	D2741	1	33	0
	D3493-1	2	62	0
	D3532-1	2	32	0
	MS21083C8	2	123	0
	NAS1149D0863J	2	189	0
Part Specifications				
Specifications could not be found.				

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QTY -041	QTY -042	QTY -043	QTY -044	PART NUMBER	DESCRIPTION
X				D2750-041	350 SKIDTUBE ASSEMBLY, LH
	X			D2750-042	350 SKIDTUBE ASSEMBLY, RH
		X		D2750-043	350 SKIDTUBE ASSEMBLY, LH
			X	D2750-044	350 SKIDTUBE ASSEMBLY, RH
1	1	1	1	D2739	WEB
8	8	8	8	D2743	SPACER
1	1	1	1	D2744	CAP
8	8	8	8	D2745	BUSHING
1				D2750-1	SKIDTUBE WELDMENT, LH
	1			D2750-2	SKIDTUBE WELDMENT, RH
		1		D2750-3	SKIDTUBE WELDMENT, LH
			1	D2750-4	SKIDTUBE WELDMENT, RH
1		1		D3488-041	BLADE FITTING, LH
	1		1	D3488-042	BLADE FITTING, RH
4	4	4	4	D3490-1	SPACER
4	4			D3490-3	SPACER
		4	4	D3490-5	SPACER
8	8	8	8	D3492-041	PLUG ASSEMBLY
8	8			D3492-043	PLUG ASSEMBLY
		8	8	D3492-045	PLUG ASSEMBLY
1	1	1	1	D3535-25	WEARSHOE
1	1	1	1	D3536-25	GASKET
3	3	3	3	D3537-1	WEARPAD
8	8	8	8	D3631-1	WASHER
1	1	1	1	D3791-1	WEARPLATE
1	1	1	1	D3793-1	WEARSHOE
1	1	1	1	D3793-3	WEARSHOE
1	1	1	1	D3794-1	GASKET
1	1	1	1	D3794-3	GASKET
38	38	38	38	ALS4-1032-225	INSERT (OR ALS7-1032-225, AKS4-1032-225, AELS-1032-225)
34	34	34	34	AN3C5A	BOLT
4	4	4	4	AN3C8A	BOLT
4	4	4	4	AN8C44A	BOLT
1	1	1	1	AN8C35A	BOLT
38	38	38	38	AN860C10L	WASHER
1	1	1	1	AN860C816L	WASHER
4	4	4	4	MS21043-6	NUT
1	1	1	1	MS21083C8	NUT
4	4	4	4	NAS1515H3L	WASHER

GENERAL NOTES:

- MATERIAL: MAKE D2750-1/2/3/4 FROM D2600-3 EXTRUSION (INITIAL LENGTH = 120.0).
- FINISH: ACID ETCH, ALODINE ASSEMBLY PER DART QSI 005 4.1 PRIOR TO INSTALLING D2739 WEB.
 STANDARD: PRIME (REF. 4.2.1.3.3) AND PAINT WHITE PER DART QSI 005 4.2
 OPTIONAL: POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
 BLACK ANTI-SKID PAINT AS INDICATED TO 1.0 ABOVE SKIDTUBE CENTER-LINE PER DART 005 4.4 (OPTIONAL).
- TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- UNITS: INCHES UNLESS OTHERWISE NOTED
- BREAK SHARP EDGES: N/A
- IDENTIFICATION: N/A
- WEIGHT: D2750-041/-042/-043/-044 = 26.5 LBS
- WELD PER DART QSI 004
- INSTALL ALS4-1032-225 INSERTS AFTER FINISH AS INDICATED. DRILL "F" SIZE HOLES (Ø0.297) FOR WEARSHOE INSERTS
- FINAL CONFIGURATION SHOULD HAVE THE FOLLOWING MINIMUM MECHANICAL PROPERTIES:
 MINIMUM YIELD TENSILE STRENGTH = 35 KSI
 MINIMUM ULTIMATE TENSILE STRENGTH = 38 KSI
- COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF
 FINISH WITH MEK DEGREASER.
- SPACER AND PLUG INSTALLED SAME AS SECTION AJ-AJ EXCEPT HORIZONTAL
- SPACER AND PLUG INSTALLED SAME AS SECTION AP-AP EXCEPT HORIZONTAL

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G	CORRECTED TOLERANCE ON Ø0.500 THRU HOLE: IS +0.010/-0.000, WAS +0.100/-0.000 (ZN B3-4, B2-5); ADD VIEW TO CONTROL FWD BEND ORIENTATION (ZN D-1-4/5-6/7); UPDATED FINISH OPTIONS; INSIDE OF TUBE NO LONGER SPRAYED WITH LPS-3. REASON: PART13-276 AND NCR13-2757	MB	13.07.11
F	INCORPORATE DSI 9413: QTY (3) D3537-1 WAS QTY (5) (ZN C8-1); D3791-1/3 REPLACES D3535-1/3-35 (ZN C8-1); D3794-1/3 REPLACES D3536-1/3-35 (ZN B8-1); ADD D3791-1 (ZN C8-1); WEARSHOE HOLES UNDER FWDRAFT SADDLE REMOVED (8 PL) WEARSHOE HARDWARE QTY UPDATED (ZN B8-1); D3488-041/-042 HARDWARE UPDATED (ZN C1-8, 9, 10, 11); ADD NOTE 12 AND 13 (ZN A6-1); REASON: REF. NCR 08-043	PH	08.07.16
E	CHANGE TO STAINLESS STEEL WEARPLATES; ADD RUBBER GASKETS; CHANGE INSERTS; ADD D3631-1; REMOVE QTY (38) NAS1515H3L; REMOVE QTY (10) NAS1515H3L; REMOVE D2741, QTY (2) AN860C816; REMOVE QTY (2) MS21083C8	CB	07.05.17
D	ADD HOLES AND SPACERS FOR APICAL FLOATS; INCORPORATE DED 9133/6157	PH	06.01.05
C	ADD D2750-3/D2750-4; INCORPORATE D2738 AND D2740	CP	98.11.18
B	CHANGE MS24894-S293 TO AN8-16A	CP	98.09.01
A	NEW ISSUE	DS	98.04.16
REV.	DESCRIPTION	BY	DATE
DESIGN	MM		
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APPROVED			
DE APPR.			
DATE	13.07.11		

DART AEROSPACE USA, INC.

KENT, WA

DRAWING NO.

D2750

TITLE

350 SKIDTUBE ASSEMBLY

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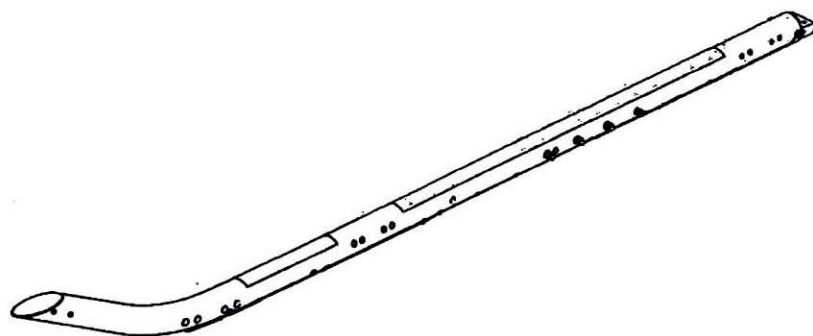
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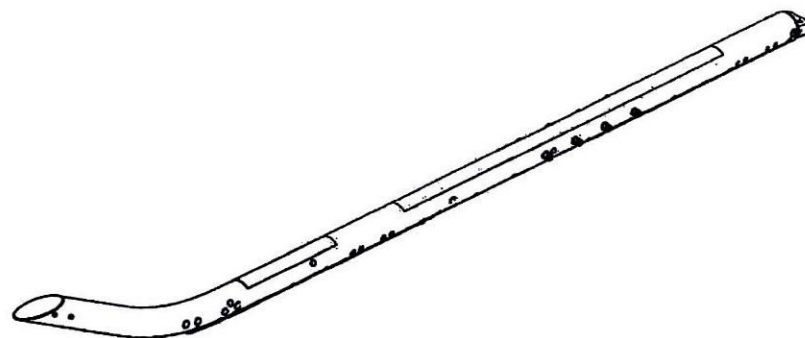
SHEET 1 OF 11

SCALE

NTS



D2750-041 350 SKIDTUBE ASSEMBLY, LH



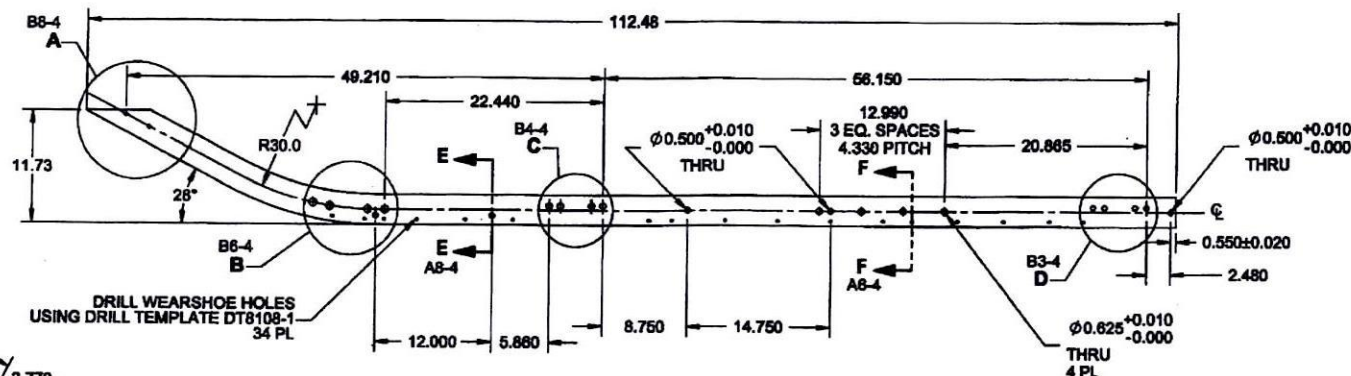
D2750-042 350 SKIDTUBE ASSEMBLY, RH

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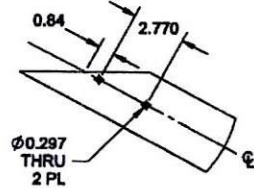
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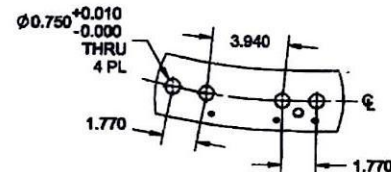
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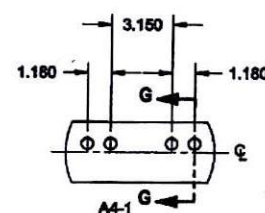
D2750-1 LH SKIDTUBE



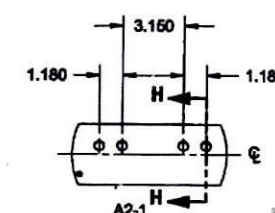
DETAIL A
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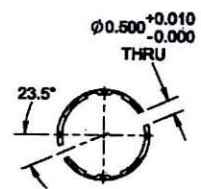
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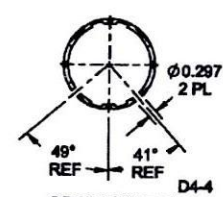
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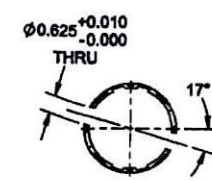
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SCALE 2X



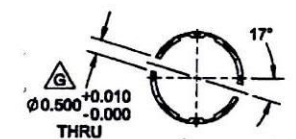
SECTION E-E
SCALE 3X, 2 PL



SECTION F-F
SCALE 3X, 17 PL



SECTION G-G
SCALE 3X, 4 PL



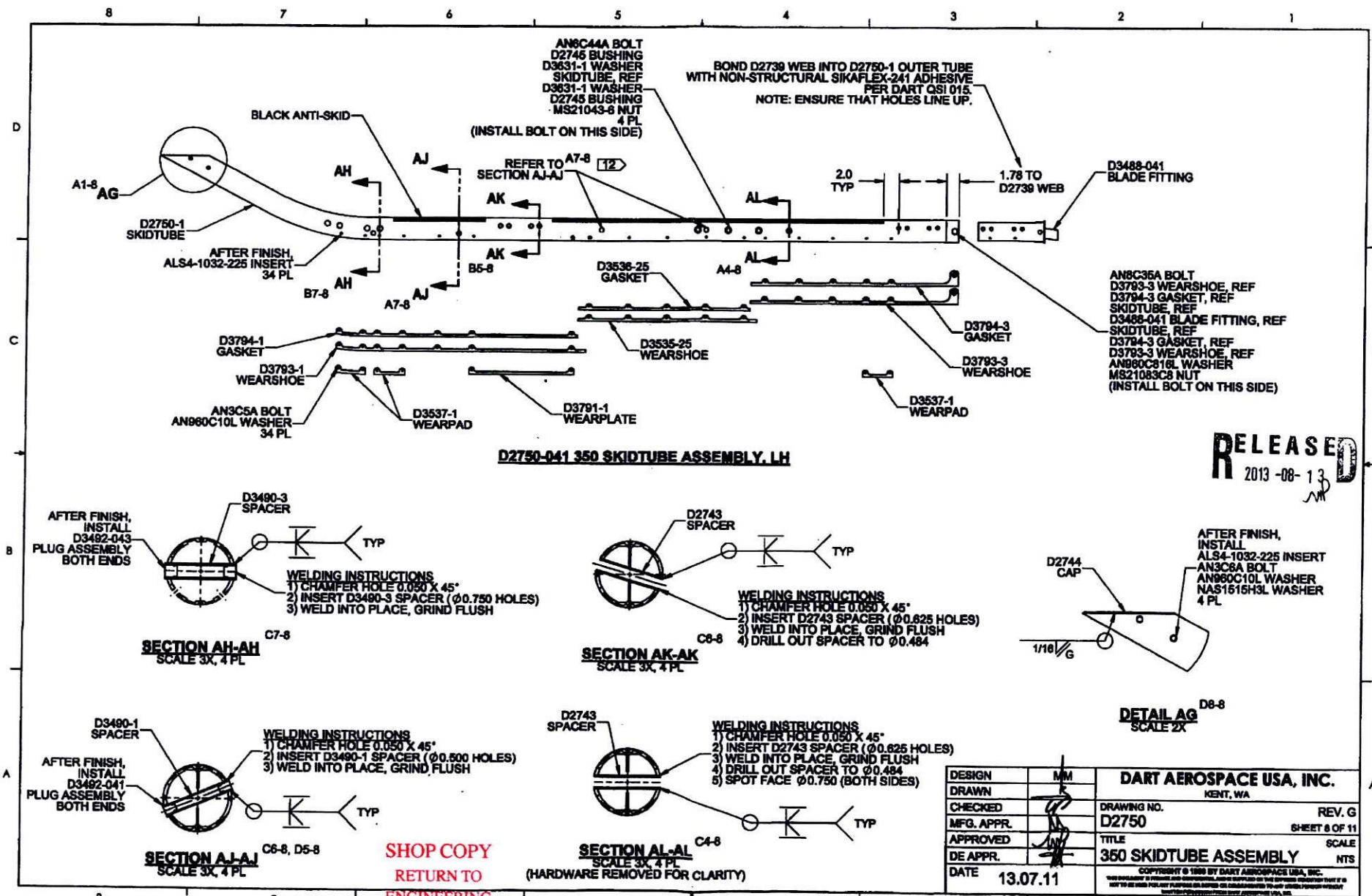
SECTION H-H
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Container View (Active) - Master Unit Containers

Master Unit No	Container No	Part No	Part Name	From Container	Current Location	Quantity
001622	S050803	AN8C21A	Bolt	FM137162	OVER004	2
001622	S050802	D2741	Replacement Blade	F163260-1	ST538	1
001622	S050800	D3493-1	Washer	S031096	ST037	2
001622	S050799	D3532-1	Spacer	S026734	ST038	2
001622	S050798	MS21083C8	Nut	S016888	ST297	2
001622	S050797	NAS1149D0863J	Washer	F125268	ST263	2

Note: Ad hoc query view of Part.dbo.Container where Container.Active = 1.

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